

Date: Tuesday, 28/04/2009 12:38:23 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SADDLE FITTING, AFT (OUTBOARD/INBOARD)		
Job Number	: 47566			Part Number	: D2573	
Estimate Number	: 10533			Drawing Number	: D2573 REV E	
P.O. Number	:			Project Number	: N/A	
This Issue	: 28/04/2009		S.O. No.	:		
Prsht Rev.	: NC			Drawing Revision	: E	
First Issue	: / /		Type	: MACHINED PARTS		
Previous Run	: 47249			Material	:	
Written By	:			Due Date	: 07/05/2009	
Checked & Approved By	: <u>JUL 09. 04.28</u>			Qty:	8	
Comment	: Est: 1 As Per RevE 06-01-27 JLM			Um:	Each	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101007	Saddle Billet	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) 7075-T7351 8.25X7.75X2.5 Make from D6101-007 billet for D2573 Ensure that grain is along 7.75" length Batch No: <u>46412</u>	
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No. <u>47566</u> Double check by: _____ 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges.	
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2573 & D2574	
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

88 09/06/18

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

09-06-18 X5

7.0 POWDER COATING POWDER COATING



1111472

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: 8:30 AM

OVEN TEMPERATURE: 320°F

FINISH TIME: 9:00 AM

09-06-18 X8

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



88 09-06-18

Comment: INSPECT POWDER COAT

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: PPP. 47540-K10003

88 09/06/18 X8

10.0 QC21 FINAL INSPECTION/W/O RELEASE



09/06/19 X8

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



ME 09-06-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order:	4750
Description: Saddle, Aft Outboard				Part Number:	D2573
Inspection Dwg: D2573 Rev. E				Page 1 of 12	

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.439	0.440	0.440	0.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.501	0.501	0.500	0.504		
G	0.257	0.262		.259	0.260	0.260	0.260		
H	0.375	0.380		.376	0.377	0.377	0.377		
I	0.490	0.510		.502	0.501	0.501	0.502		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.569	0.567	0.568	0.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.125	0.126	0.126	0.126		
Q	0.115	0.135		.135	0.135	0.135	0.135		
R	0.240	0.260		.250	0.251	0.251	0.251		
S	0.115	0.135		.125	0.123	0.122	0.125		
T	0.178	0.198		.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		.240	0.238	0.239	0.238		
W	0.115	0.135		.126	0.127	0.126	0.126		
X	0.308	0.313		.311	.310	0.311	0.311		
Y	0.760	0.765		.760	0.760	0.760	0.760		
Z	0.352	0.372		.360	0.360	0.360	0.361		
AA	0.470	0.530		.500	0.500	0.500	0.500		
AB	0.615	0.635		.628	0.630	0.628	0.628		
AC	0.053	0.073		.063	0.063	0.063	0.063		
AD	0.240	0.260		.247	0.247	0.247	0.247		
AE	1.500	1.520		1.514	1.513	1.514	1.514		
AF	0.115	0.135		.120	0.120	0.120	0.120		
AG	0.240	0.280		.265	0.265	0.265	0.265		
AH	0.240	0.260		.251	0.249	0.248	0.249		
AI	2.000	2.020		2.003	2.001	2.007	2.002		
AJ	0.023	0.043		.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	SL	Audited by:	JP
Date:	09/06/15	Date:	09/06/15

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	JP SL

DART AEROSPACE LTD				Work Order:	4750
Description: Saddle, Aft Outboard				Part Number:	D2573
Inspection Dwg: D2573 Rev. E				Page 1 of 1	2 2

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

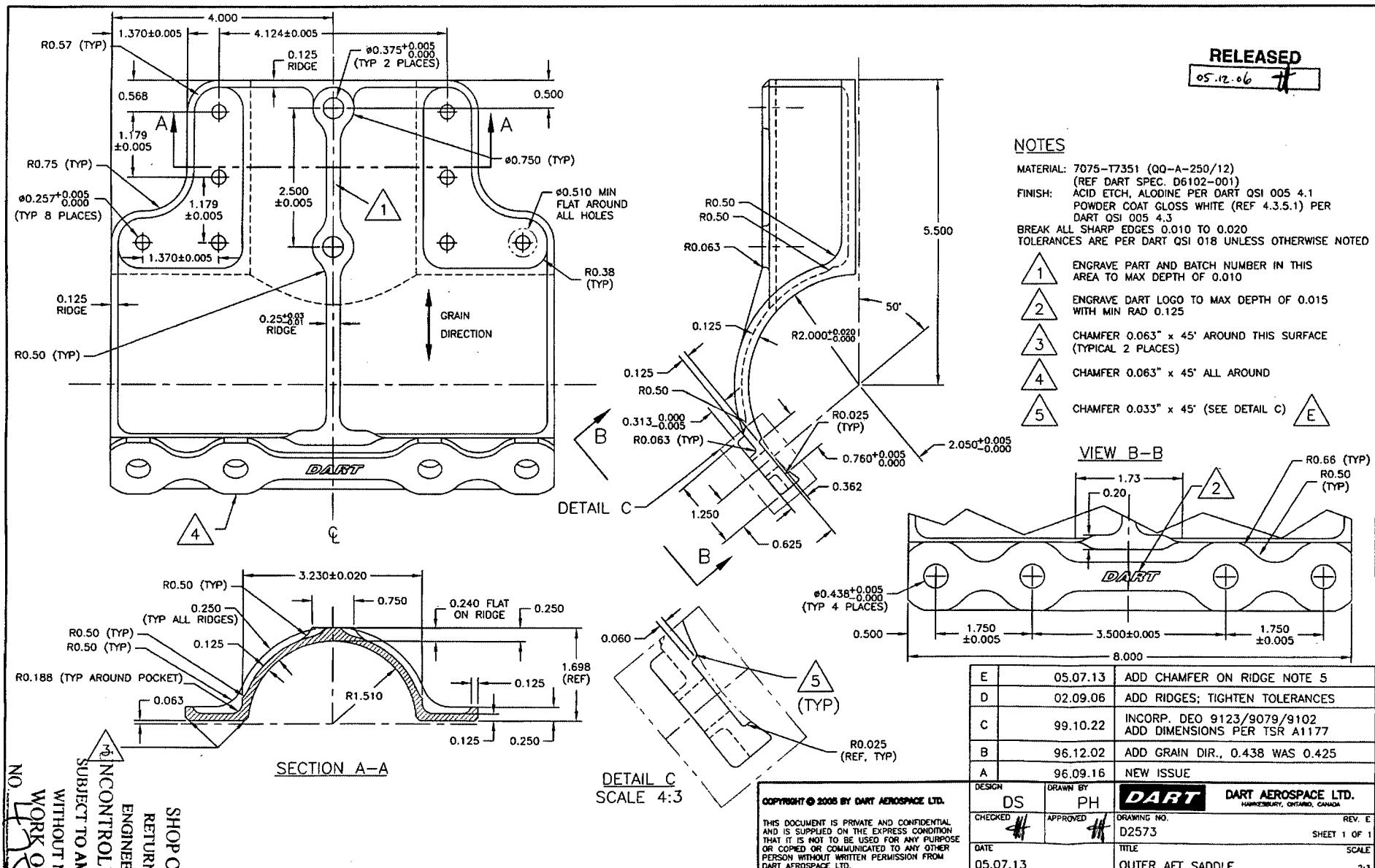
Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				15	16	17	18		
A	0.438	0.443		0.440	0.440	0.440	0.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.002	8.002	8.002		
F	0.490	0.510		0.498	0.501	0.504	0.505		
G	0.257	0.262		0.260	0.260	0.260	0.260		
H	0.375	0.380		0.377	0.377	0.377	0.377		
I	0.490	0.510		0.500	0.500	0.501	0.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.568	0.568	0.566	0.567		
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U	3.210	3.250		3.230	3.230	3.230	3.230		
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W	0.115	0.135		0.127	0.126	0.126	0.126		
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Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.360	0.360	0.362	0.362		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.627	0.635	0.631	0.630		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
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AH	0.240	0.260		0.247	0.248	0.247	0.247		
AI	2.000	2.020		2.002	2.002	2.003	2.002		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	J.A.	Audited by:	J.P.
Date:	09/06/16	Date:	09/06/14

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	J.P. JLM

RELEASED

05.12.06



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